

Work Order ID 78850

January-16-12 2:17:00 PM

J
78850

RUSH For Thursday

Page 1

Item ID: D3608-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Lower Doubler
 Start Date: 16/01/2012 Start Qty: 6.00 ***6*** Cust Item ID:
 Required Date: 25/01/2012 Req'd Qty: 6.00 ***6*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 12/01/16 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3608	C								
100	FLOW WATER JET	0.00							
100									
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D3608								
<i>304 .040</i>	Dwg Rev: <u>E</u>								
	Prog Rev: <u>E</u>								
	2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.00							
Quality Control									
120	QC8- Inspect parts - second check	0.00							
120									
QC	Memo	0.00							
Quality Control									

B12-1-16

(8)

B12-1-16

8/2/17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

78850

Page 2

N900040100

Setup Start *NS1*

Stop *NS2*

6

Cust Item ID:

6

Customer:

Reference:

Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

**Insp.
Stamp**

Identify as per dwg & Stock Location: ST 175 0.00

150

Packaging

Packaging

Memo

0.00

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Quality Control

Memo

0.00

SP 12-01-18

12/1/82

12-01-8
(4)

W/O:		WORK ORDER CHANGES					
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Picklist Print

January-16-12 2:17:04 PM

Page 1

Work Order ID: 78850

78850

Parent Item: D3608-1

D3608-1

Parent Item Name: Lower Doubler

Start Date: 16/01/2012

Required Date: 25/01/2012

Start Qty: 6.00

Required Qty: 6.00

Comments:

IPP Rev:A New Issue 07-03-26 JLM
 IPP Rev:B 08-10-15 preliminary issue DD verified by:EC
 IPP Rev:C 08-12-11 rev.A as per dwg DD verified by:EC IPP
 Rev:D 10.02.16 rev.B as per dwg DD verified by:EC IPP Rev:E
 10.11.17 as per PC1 dwg DD verified by:EC IPP Rev:F 10.11.29 as
 per revC dwg DD verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S20GA		Purchased	No			100	sf	242.5165	0.7392	4.668632	6.		

M304S20GA

304/316 .040 Sheet

**

B 12-1-16

Location

Loc Qty

Loc Code

MAT020

242.5165

116623

0.2

117933

27.3442

118400

25.6723

118964

36.5

119346

152.8

119346

78

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 78858
Description: Lower Doubler		Part Number: D3608-1
Inspection Dwg: D3608	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.098	+0.004/-0.001	.098	2		✓ Bol	
1.82	+/-0.030	1.812	2		✓	
0.50	+/-0.030	.503	2		✓	
11.63	+/-0.030	11.621	2		T Bol	
81.00	+/-0.030	81.04	1		Row 102	
1.350	+/-0.010	1.348	2		✓	
2.25	+/-0.030	2.261	2		✓	
1.81	+/-0.030	1.817	2		✓	
3.750	+/-0.010	3.756	2		✓	
1.250	+/-0.010	1.252	2		✓	
8.90	+/-0.030	8.888	2		T	
0.400	+/-0.010	.402	2		✓	
1.350	+/-0.010	1.345	2		✓	
0.345	+/-0.010	.341	2		✓	
1.875	+/-0.010	1.880	2		✓	
6.73	+/-0.030	6.735	2		✓	
2.90	+/-0.030	2.907	2		✓	
6.98	+/-0.030	6.983	2		✓	
1.38	+/-0.030	1.376	2		✓	
8.44	+/-0.030	8.437	2		T	
0.040	+/-0.010	.037	2		✓	

Measured by: B	Audited by: S	Preliminary Approval:
Date: 12-1-16	Date: 12/1/17	Date:

Rev	Date	Change	Revised by	Approved
A	09.05.11	New Issue	KJ	
B	10.02.18	Dimensions updated per Dwg Rev B	KJ	
C	10.12.21	Dimensions updated per Dwg Rev C	KJ	

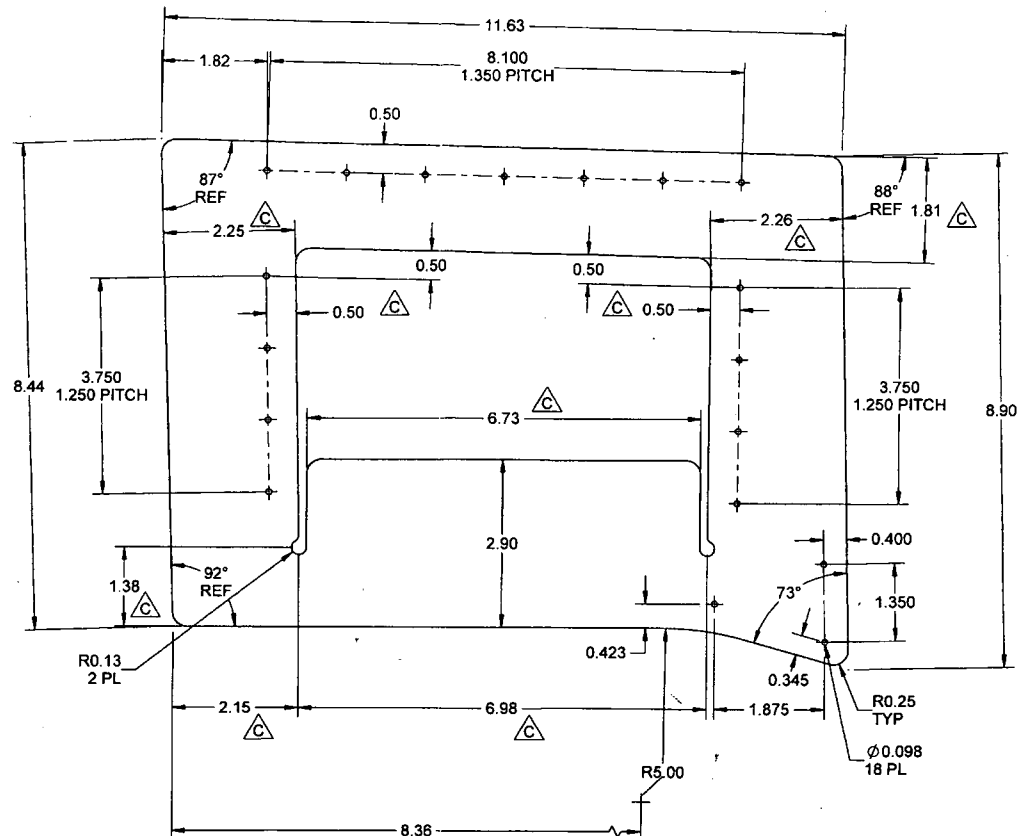
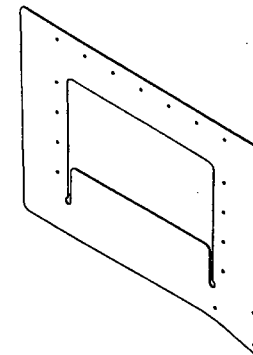
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NOTE: Date & initial all entries



STOP
 UNCONTROLLED
 SUBJECT TO APPROVAL
 WITHOUT
 WORK ORDER
 NO. 78850 M.L.J
 12/01/16

D3608-1 LOWER DOUBLER

- NOTES:**
- 1) MATERIAL: AISI 304/316 SS SHEET, 20 GAUGE
PER MIL-S-5059, OR AMS 5513 (304) OR AMS 5524 (316)
OR ASTM A240 OR ASTM SA240
REF DART SPEC M304S20GA
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
 - 7) WEIGHT: 0.76 lbs

RELEASED
 2010-11-23

C	OFFSET TOP AND VERTICAL EDGES OF RECTANGULAR OPENING BY 0.250 OUTWARDS; UPDATE IDENTIFICATION REFERENCE	MB	10.11.19
B	OFFSET TOP AND VERTICAL EDGES OF RECTANGULAR OPENING BY 0.250 INWARDS; ELIMINATE D3608-1F-3F; DELETED BENDING DETAILS, REASON: D3608-1/3 NOW SOLD TO CUSTOMERS UNBENT PER PAR#09-097	MB	10.02.05
A	NEW ISSUE	MB	07.04.11
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.11.19		

DART AEROSPACE LTD
 HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D3608
 REV. C
 SHEET 1 OF 2
 TITLE DOUBLER
 SCALE NTS

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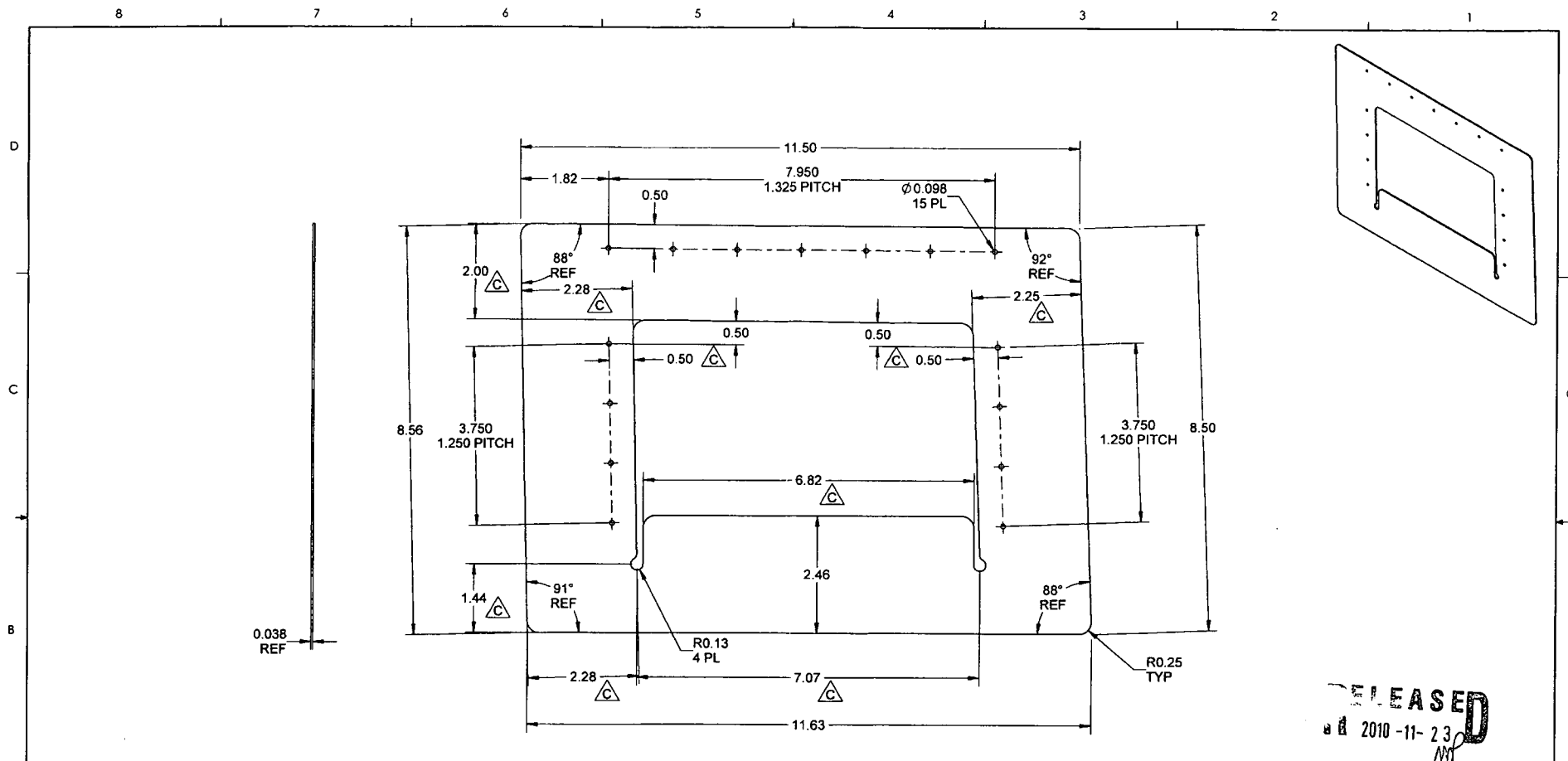
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NOTE: Date & initial all entries

78850



D3608-3 UPPER DOUBLER

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET, 20 GAUGE
PER MIL-S-5059, OR AMS 5513 (304) OR AMS 5524 (316)
OR ASTM A240 OR ASTM SA240
REF DART SPEC M304S20GA
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.75 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3608	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		DOUBLER	NTS
DATE	10.11.19	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

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